

536

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23928
<b>Description:</b> Pedal Assembly		<b>Part Number:</b>	D3204-041
<b>Dwg:</b> D3204 Rev. A		<b>Qty:</b>	8
Page 1 of 2			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D3204-041 Pedal Assembly D3204-1 Tube D3204-7 Bushing <b>Dwg not required</b>		05/08/05	8
2	MV	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) <b>Identify for D3204-3</b>	YD	05/08/11	8
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) <b>Identify for D3204-5</b>	YD	05/08/12	8
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) <b>Identify for D3204-11</b>	YD	05/08/12	8
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) <b>Identify for D3204-9</b>	YD	05/08/12	8
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 <b>Identify as D3204-3</b>	SD	05.08.15	8
7	QC2	Inspect parts as they come off the CNC machine	SD	05.08.15	8
8	MV	Deburr	SD	05.08.15	8
9	QC8	Second check	EC	05.08.15	8
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 <b>Identify as D3204-5</b>	SD	05.08.15	8
11	QC2	Inspect parts as they come off the CNC machine	SD	05.08.15	8
12	MV	Deburr	SL	05.08.15	8
13	QC8	Second check	EC	05.08.15	8
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 <b>Identify as D3204-11</b>	BL	05.08.16	8
15	QC2	Inspect parts as they come off the CNC machine	BL	05.08.16	8
16	MV	Deburr	BL	05.08.16	8
17	QC8	Second check	YML	05/08/16	8
18	MV	Machine D3204-9 as per Folio FA357 and Dwg D3204 <b>Identify as D3204-9</b>	BL	05.08.16	8
19	QC2	Inspect parts as they come off the CNC machine	BL	05.08.16	8

105  
82  
83  
85  
104  
81

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23928
<b>Description:</b> Pedal Assembly	<b>Part Number:</b>	D3204-041
<b>Dwg:</b> D3204 Rev. A	<b>Qty:</b>	
Page 2 of 2		

Step	Location	Procedure	By	Date	Qty								
20	MV	Debur	TG	05.08.16	8								
21	QC8	Second check	JML	05/08/16	8								
22	WA	<b>Cut (2) D3204-13 per Assembly</b> Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) <b>Identify as D3204-13</b> Batch: <u>M15120</u>	CPL	05.08.29	8								
23	WA	Grind hypotenuse side	CPL	05.08.29	8								
24	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3204-1</td><td>Tube</td><td><u>B23524</u></td></tr></table> <b>Identify as D3204-041</b>	Qty	Part Number	Description	Batch	1	D3204-1	Tube	<u>B23524</u>	CPL	05.08.29	8
Qty	Part Number	Description	Batch										
1	D3204-1	Tube	<u>B23524</u>										
25	QC5/9	Inspect weld	M	05/09/06	8								
26	FP	Chemical Conversion Coat as per QSI 005 4.1	M	05/09/07	8								
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 <b>Note: Cover holes for bushing</b>	FL	05/09/07	8								
28	QC3	Inspect Powder Coat	M	05/09/07	8								
29	GA	Install D3204-7 bushing as shown in Dwg D3204 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3204-7</td><td>Bushing</td><td><u>B24722</u></td></tr></table>	Qty	Part Number	Description	Batch	2	D3204-7	Bushing	<u>B24722</u>	SB	05/11/10	8
Qty	Part Number	Description	Batch										
2	D3204-7	Bushing	<u>B24722</u>										
30	QC5	Inspect work to Step 29	J	05-11-10	8								
31	ST	Identify and Stock D3204-041 Qty: <u>8</u> D3204-1 Qty: _____ D3204-7 Qty: _____ <b>Note: D3204-1/-7 are stocked in welding cell</b> LOC: 95	CL	05/11/10	8								
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part <u>81.25</u>	SAC	05-11-21	8								
33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 <u>87.43</u> Travelers: D3204-041 D3204-1 D3204-7	DP	05/11/21	8								

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Added Travelers	KJ/RF	

RELEASED

04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_







RELEASED  
JAN 27 1965



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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 02, 2005  
01:38 pm

Work Order No	:	0023928	Department Code:	
Project Name	:	D3204-041	Burden Flags	: NNNNNNN
Project For	:	WK536	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3204-041	Invoice Number	:
Description	:	Pedal Assembly	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	08-02-05		
Est Finish Date	:	09-05-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:		\$0 Posted to Finished Goods	
Approval Rec'd	:			

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

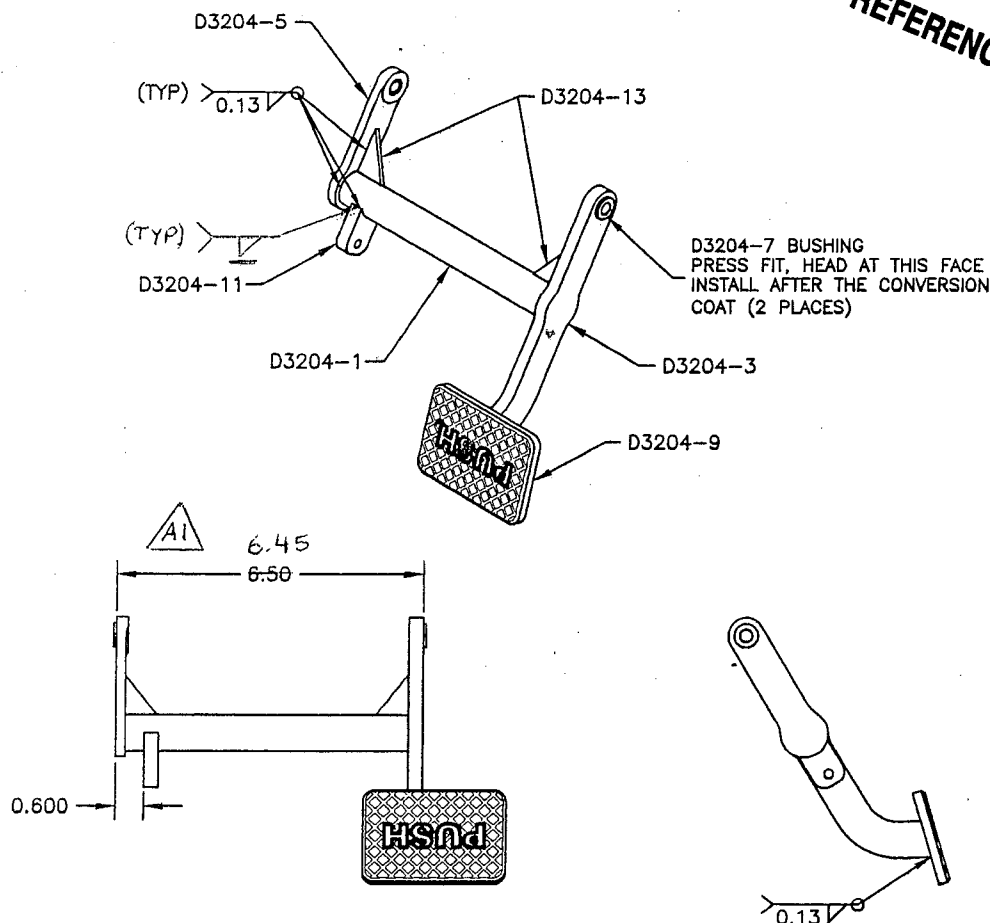
CONTROLLED COPY

**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
07.04.30

REFERENCE ONLY

**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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Date: Friday, 11/11/2005 8:18:31 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	PEDAL ASSEMBLY
<b>Job Number</b> :	23928		
<b>Estimate Number</b> :	10504		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3204041
<b>This Issue</b> :	11/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3204 REV. A1
<b>First Issue</b> :	/ /	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	A1
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	11/18/2005
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	8
<b>Comment</b> :	Est:C 05.08.11 Added Step 25 KJ/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D32041	Tube
2.0	D32043	Arm
3.0	D32045	Arm
4.0	D32049	Pedal
5.0	D320411	Plate
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured. Identify as D3204-041		
7.0	QC5/9	WELD INSPECTION
<b>Comment:</b> WELD INSPECTION		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
9.0	POWDER COATING	POWDER COATING
<b>Comment:</b> POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 ***Cover holes for bushing***		

Date: Friday, 11/11/2005 8:18:32 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 23928

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11.0

D32047

Bushing

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
10:44 am

Work Order No : 0023928  
Project Name : D3204-041  
Project For : WK536  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3204-041  
Description : Pedal Assembly  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 08-02-05  
Est Finish Date : 09-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	32.49	100.00		
Production Cost :	0.00	576.84	100.00	0.00	576.84
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	20.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	576.84	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	576.84			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -576.84)

MIS open box  
u  
11-11